

Work Order ID 71781

Tuesday, July 12, 2011 8:20:23 AM



Page 1

Item ID: D3646-4

Accept



Setup Start

Revision ID: ~~PRELIM~~

Stop



Item Name: Arm

Start Date: 7/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/12/2011 Req'd Qty: 1.00



Customer:

Reference:

PRELIMINARY ISSUE

Run Start

Stop

Approvals: Process Plan: MF Date: 11-07-12 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3646	PC1 C 155

100 0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Punch to length as per Dwg D3646 & template DT8959

① 12 11-07-11

110 0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Deburr

2- Bend as per dwg D3646

① 12 11-07-11

120 0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

MF 11 07 12 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3646-4

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Setup Start



Revision ID: PRELIM

Stop



Item Name: Arm

Start Date: 7/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/12/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

Powder Coating

140

QC3- Inspect Part Finish

0.00



QC

Memo

Quality Control

150

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

Packaging

X Y M 11/07/12

① 11-07-12

11/07/12 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Arm

Start Date: 7/12/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/12/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/7/12

MF 11-07-12

POSITIVE RECALL

EFFECTIVE 11/07/12 AUTH

RELEASED ASS DATE 11.07.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, July 12, 2011 8:20:21 AM

Page 1

Work Order ID: 71781



Parent Item: D3646-4



Parent Item Name: Arm



Start Date: 7/12/2011

Required Date: 7/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP revA 11.07.12 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035 		Purchased	No			100	f	175.7796	3.1	3.263158			
304 RD Tube .500 x .035W													

Location

Loc Qty

Loc Code

MAT017

175.779638

115535

2.33

116720

1.66068

117598

171.788958

10

11.07.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Dart Aerospace Ltd

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

A

D

C

B

A

28.50±0.13

2.25±0.13

5.75±0.13

15°

R0.50
TYP

45°

D3646-4 ARM

VIEW D-D

C4-3

D C6-3

VIEW F

B6-3


30°





VIEW E-E

D5-3

30°

NOTES:

- 1) MATERIAL: AISI 304/316 SS TUBE $\phi 0.500 \times 0.035$ WALL PER ASTM A213/A269 OR ASME A213 (REF DART SPEC. M304TR0500W.035)
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3646-4" AND B/N "BXXXXX" PER DART QSI 044 8.1 USING REMOVABLE TAG
- 7) WEIGHT: 0.57 lbs
- 8) DELETED AT REV C. 
- 9) PUNCH BOTH ENDS PER SPEC CONTROL DWG D2727

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3646	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ARM	NTS
DATE	11.07.11	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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RELEASED
2011-07-12
AN

71781

8 7 6 5 4 3 2 1